

Rush Today.

Work Order ID 166519

166519

Page 1

Tuesday, September 26, 2017 9:34:38 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 9/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:  Date: SEP 26 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D
DSI9690	A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

DAS
28
9-89

SEP 26 2017

115

115

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DRAWING

N/A. CUSTOMER WILL ASSEMBLE
AFTER PAINTING. 11/09/26

Work Order ID 166519

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Item ID: D350-588-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Door Assembly
Start Date: 9/26/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/26/2017 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC6- All purchased or subcontracted products Memo Inspect as per Dwg D2445. Audit process sheet.	0.00 0.00				1			DAS 38 9-89 SEP 25 2017
140 *140* Small Fab Small Fab Small Fab	Small Fab Memo Assemble all of the above parts as per Dwg D350-588	0.00 2.79							DAS 38 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02							DAS 38 9-89

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 9/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.03							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.01							
Packaging	Location :FG021								

DAS
27
9-89DAS
28
9-89

SEP 26 2017

DAS
28
9-89

SEP 26 2017

Work Order ID 166519***166519***

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Item ID: D350-588-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Door Assembly
Start Date: 9/26/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/26/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89
SEP 26 2017
DAS
21
9-89
SEP 26 2017

Picklist Print

Tuesday, September 26, 2017 9:34:46 AM

Page 1

Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP RevR add pick
kit DD 10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER
DSI9690 DD VERF:JLM IPP RevT 17.06.01 DSI9760-011 DP Verify
DD IPP REV:U 17.08.14 REMOVE DSI9760 DD
VERF:DP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445		Manufactured	No				Each	1.0000		1			DAS 07 9-89
D2445									**	①			
Aft Door 350													

USE (B: 149032)

Location	Loc Qty	Loc Code
ST378	1	
116619	1	

AN526C832R9		Purchased	No			140	Each	240.0000	8	8			DAS 07 9-89
AN526C832R9									**				
Screw													

Location	Loc Qty	Loc Code
ST327	240	
M136983	3	
M137597	112	
M138237	125	

D2143		Manufactured	No			140	Each	24.0000	1	1			DAS 07 9-89
D2143									**				
Hinge Bracket													

Location	Loc Qty	Loc Code
ST002	24	
141033	1	
150285	1	
152427	10	
156245	12	

①

Picklist Print

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Tuesday, September 26, 2017 9:34:46 AM

Work Order ID: 166519

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2144

Manufactured No

140

Each

25.0000

1

1

**

DAS
07
9-89

D2144

Hinge Doubler

SEP 26 2017

Location

Loc Qty

Loc Code

ST002

11

150971

11

ST012a

14

156274

14

D2463

Manufactured No

140

f

259.5771

7.25

7.25

**

DAS
07
9-89

D2463

1/2" Seal (\$ per foot)

17/09/17
SEP 26 2017

Location

Loc Qty

Loc Code

ST409

259.5770896

140013

3.9081E-05

148875

0.00547229

160119

259.571578

7.25 ft

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585

Manufactured No

140

Each

28.0000

2

2

**

DAS
07
9-89

D2585

Latch Clamp

17/09/17
SEP 26 2017

Location

Loc Qty

Loc Code

ST008

28

139075

2

161798

8

162498

18

2

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

24.0000

2

2

D2586

Door Latch

**

DAS
07

9-89

17/09/26
SEP 26 2017

Location

Loc Qty

Loc Code

FG

11

139228

6

152211

4

154875

1

ST481

13

154875

4

161467

9

2

D2621

Manufactured No

140

Each

28.0000

2

2

D2621

Latch Plate

**

DAS
07

9-89

17/09/26
SEP 26 2017

Location

Loc Qty

Loc Code

FG

2

88616

2

ST009

26

141106

1

142793

10

150495

15

2

D2857-1

Manufactured No

140

Each

10.0000

1

1

D2857-1

Hinge Bracket

**

DAS
07

9-89

17/09/26
SEP 26 2017

Location

Loc Qty

Loc Code

FG

5

144748

1

150331

3

91914

1

ST012

5

152448

5

1

Picklist Print

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Work Order ID: 166519

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

140

Each

16.0000

1

1

D2857-2

Hinge Bracket

**

DAS
07
9-89

SEP 26 2017

Location

Loc Qty

Loc Code

FG

5

140972

2

152184

3

ST012

11

152184

1

161675

10

MS21042L08

Purchased

No

140

Each

1,236.000

8

8

MS21042L08

Nut

**

DAS
07
9-89

SEP 26 2017

Location

Loc Qty

Loc Code

GA

261

m135978

46

m138333

215

ST303

975

m138045

23

m138237

15

m138333

937

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Page 5

Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

1,300.000

2

2

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

44

m135945

44

GA

302

m134360

102

M136665

200

ST303

954

m138230

394

m138326

60

m138408

500

SEP 26 2017

MS27039-1-15

Purchased

No

140

Each

87.0000

2

2

MS27039-1-15

Screw

**

Location

Loc Qty

Loc Code

GA

47

m127916

1

m136554

46

ST280

40

m137886

40

SEP 26 2017

NAS1149D0363J

Purchased

No

140

Each

993.0000

2

2

NAS1149D0363.J

Washer

**

Location

Loc Qty

Loc Code

GA

384

m137963

384

ST263

609

m138336

609

SEP 26 2017

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

140

Each

1,794.000

8

8

NAS1149DN832J

Washer

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

1794

M131697

46

M137587

1748

AN526C1032R7

Purchased

No

155

Each

107.0000

2

2

AN526C1032R7

Screw

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST326

107

M128403

107

AN526C832R8

Purchased

No

155

Each

164.0000

8

8

AN526C832R8

Screw

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST327

164

m128403

8

m129706

30

m135978

26

m137597

100

DAS
28
9-89

Picklist Print

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2150

Manufactured No

155

Each

43.0000

2

2

D2150

Packer Doubler, Hinge

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST002

23

110792

2

121844

8

152300

13

ST012a

20

156276

20

SEP 26 2017

DAS
28
9-89

D2151

Manufactured No

155

Each

38.0000

2

2

D2151

Packer Doubler

**

68-6
17
SVC

Location

Loc Qty

Loc Code

ST002

18

152281

18

ST012a

20

156257

20

SEP 26 2017

DAS
28
9-89

D2153

Manufactured No

155

Each

41.0000

1

1

D2153

Door Prop

**

68-6
17
DAS

Location

Loc Qty

Loc Code

ST362

41

158104

5

161471

36

SEP 26 2017

DAS
28
9-89

Picklist Print

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2154

Manufactured No

155

Each

26.0000

1 1

D2154

Bracket, Stud

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST002

26

114213

1

118894

4

145373

3

152222

10

156214

8

DAS
28
9-89

D2237

Manufactured No

155

Each

24.0000

2 2

D2237

Striker Plate

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST004

24

161662

24

DAS
28
9-89

D2461

Manufactured No

155

f

276.2420

7.25 7.25

***D2461*-087**

Neoprene 'D' Seal (\$Per Foot)

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST407

276.2419638

144533

276.241964

DAS
28
9-89

(D2461-0870) cut (1) at 87.00

**** per kit****

D2589

Manufactured Yes

155

Each

21.0000

1 1

D2589

Keys, Key Chain

**

SEP 26 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST008

21

132942

21

DAS
28
9-89

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D2690-17 Manufactured No

155 Each

15.0000

1

1

D2690-17

Cable

**

Location

Loc Qty

Loc Code

ST009

5

120107

1

152174

4

ST012a

10

156171

10

SEP 26 2017

DAS
27
9-89

DA
28
9-89

D2858-1 Manufactured No

155 Each

29.0000

1

1

D2858-1

Hinge Bracket

**

Location

Loc Qty

Loc Code

ST012

17

152740

6

162847

11

ST012a

12

156173

12

SEP 26 2017

DAS
27
9-89

DAS
28
9-89

D2858-2 Manufactured No

155 Each

16.0000

1

1

D2858-2

Hinge Bracket

**

Location

Loc Qty

Loc Code

FG

2

77020

2

ST012

14

152277

14

SEP 26 2017

DA
27
9-89

DAS
28
9-89

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

D5080-041

Manufactured No

155 Each

26.0000

2 2

D5080-041

Striker Plate Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

st138

26

126722

6

160686

20

FG-778150-550-ROL

Purchased

No

155 sf

516.8367

1 1.333333

***FG-778150-550-ROI ***

7781 9 oz Glass 50" x 125 yd

**

SEP 26 2017

Location

Loc Qty

Loc Code

CA2

388.5000450

M127701

4.4850E-05

M134550

388.500000

st417

128.336667

M127701

1

M134550

127.336667

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155 Each

6,922.000

12 12

MS20426AD3-4

RIVET

DAS
28
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

5596

m134294

1921

m136444

3675

ST312

1326

m134294

1326

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SEP 26 2017

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27
9-89

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Work Order ID: 166519

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

155

Each

1,122.000

18

18

MS20470AD4-5

**

RIVET, UNIVERSAL HEAD

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

588

m136851

588

ST310

534

m136851

534

155

Each

1,236.000

10

10

MS21042L08

Purchased

No

MS21042L08

**

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

261

m135978

46

m138333

215

ST303

975

m138045

23

m138237

15

m138333

937

155

Each

1,300.000

4

4

MS21042L3

Purchased

No

MS21042L3

**

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

44

m135945

44

GA

302

m134360

102

M136665

200

ST303

954

m138230

394

m138326

60

m138408

500

SEP 26 2017

SEP 26 2017

SEP 26 2017

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

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Work Order ID: 166519

166519

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 9/26/2017

Required Date: 9/26/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

1,472.000

2

2

MS27039-08-11

SCREW

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

over006

1000

m138336

1000

ST278

472

m138336

472

SEP 26 2017

NAS1149D0363J

Purchased

No

155

Each

993.0000

2

2

NAS1149D0363.J

Washer

**

D/ 2
9-

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

384

m137963

384

ST263

609

m138336

609

SEP 26 2017

NAS1149DN832J

Purchased

No

155

Each

1,794.000

16

16

NAS1149DN832.J

Washer

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

1794

M131697

46

M137587

1748

SEP 26 2017

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-588 REV. 0
REF TCCA STC SH92-41
FAA STC SH1012NE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 166519

SEP 26 2017

1.0 PURPOSE:

The purpose of this Dart Service Instruction is to provide customers with directions to install a modified striker plate that will provide more clearance around environmental/conductive seals that protrude inboard of the door frame structure on AS355 N/NP models.

2.0 PROCEDURE:

- 1) Install D350-588-011/-041 per Section 3.1/3.2 of D350-588 as applicable, except do not install D2237 striker plates per item 10 of Section 3.1.
- 2) Remove the aft environmental/conductive seal to gain access to the door structure.
- 3) Using a fine point marker, mark location of both striker plates based on door latch location.
- 4) If D2237 Striker Plates are currently installed, remove both striker plates by drilling out rivets.
- 5) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285"$ (#30) holes into the aft bulkhead.
- 6) Drill out both rivets on the aircraft skin adjacent to the striker plate assemblies.
- 7) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285"$ (#30) holes from the aircraft skin to the striker plate assembly.
- 8) Deburr holes and remove all sharp edges.
- 9) Touch up all holes in aluminum with chemical conversion coating in accordance with MIL-DTL-5541.
- 10) Apply 0.125" thick layer of PR-1775B ProSeal to the face of D5080-041 per Figure 1.
- 11) Install D5080-041 striker plate assemblies to the aft bulkhead using CR3213-4 rivets of a suitable length, and to the skin of the aircraft using PR-1775B coated CR3213-4 rivets of a suitable length.
- 12) Reinstall environmental/conductive seal using manufacturers recommended procedure.
- 13) Install gas strut or cable assembly per D350-588 Figure 5.
- 14) Adjust both latch mechanisms to ensure adequate compression of door seal and that door skin is flush.
- 15) Check door for proper operation by opening and closing the door, and ensure latches fully lock.

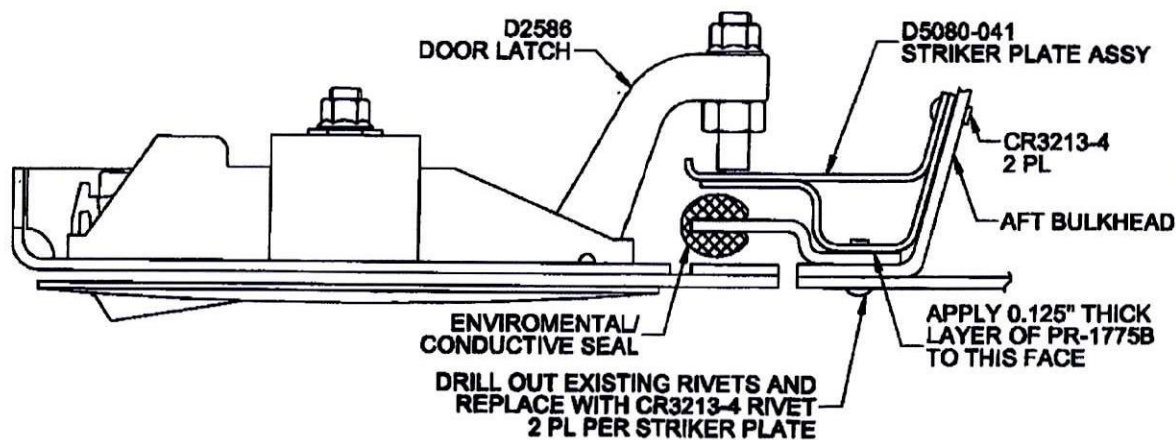


Figure 1 Striker Plate

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

A	NEW ISSUE	ML	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH82-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	ML	
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9690 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		STRIKER PLATE MOD NTS
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D350-588

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INSTALLATION INSTRUCTIONS

D350-588

Aft Door Hinge Modification Kit

EUROCOPTER AS 350/355 MODELS

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY: <u>D. Shepherd</u>	
D. SHEPHERD (DE # 02)	
DATE: <u>JAN. 17 2002</u>	
CERT. NO.: <u>SH92-41</u>	
ISSUE NO.: <u>#6</u>	

Prepared By: C. Provencal
C. Provencal
Mechanical Designer

Checked By: D. Shepherd
D. Shepherd, P.Eng.
DE #02

Released By: D. Shepherd
D. Shepherd, P. Eng.
DE #02

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Revision: **D**
Date: 02.01.17

REVISION RECORD

Revision	Issue Date	Description
-	92.07.16	New Issue
A	95.09.11	Latch bracket modification
B	96.07.11	Latch mechanism change
C	99.08.15	Re-formatted, change hinges
D	02.01.17	Correct typos

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Revision: **D**
Date: 02.01.17

1. INTRODUCTION

The Dart D350-588-041 Aft Door Assembly and D350-588-011 Aft Door Fwd Hinge Modification Kit allow for the aft baggage door to swing forward, as opposed to down. It also provides 2 key locking latches to secure the door. The -041 Aft Door Assembly provides a door with hinges and latches already in place. The -011 Aft Door Fwd Hinge Modification Kit is available to modify existing Eurocopter doors.

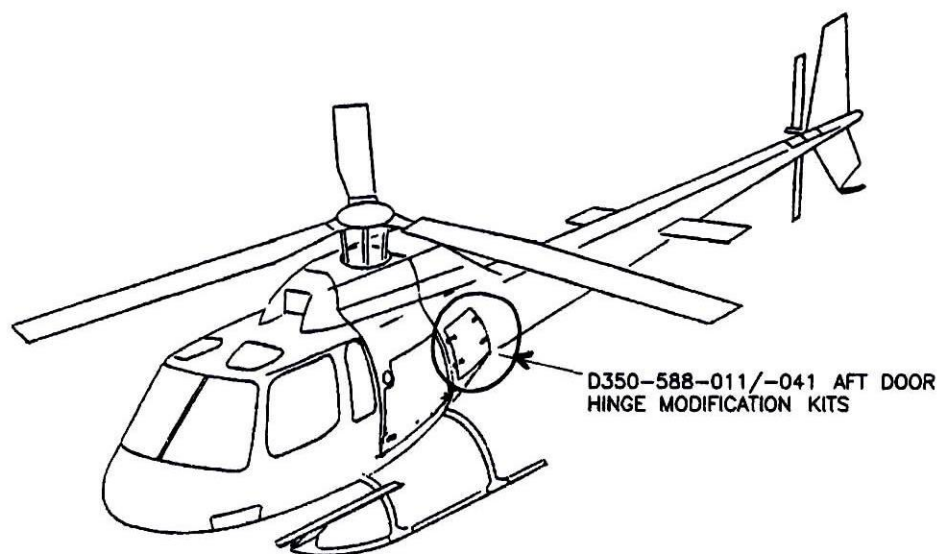


Figure 1: Location of Aft Door Hinge Kits

2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D350-588.

3. INSTALLATION INSTRUCTIONS

3.1 D350-588-041 Aft Door Assembly, Installation Procedure

Use Figures 2 to 5 when installing the D350-588-041 Assembly.

1. Remove existing door and door seal from the aircraft.
2. Place D2461-0870 Neoprene D seal around top and side edges (see Figure 3).
3. Drill out 2-3 rivets from fuselage where hinges are located (see Figure 2) for the installation of D2150/D2151 packers.
4. Assemble D2857 and D2858 hinge components to Dart door per Figure 3 if required.
5. Place Dart door on aircraft and transfer D2858 hole locations to fuselage.
6. Remove Door and drill 0.171" (4.4mm) diameter holes through aircraft skin (4 per hinge).
7. Place D2150 and D2151 packers as shown in Figure 3 and transfer drill 0.128" (3.3mm) diameter through holes of step 3.
8. Rivet D2150 and D2151 packers into place using MS20470AD4-5 rivets.
9. Install Door on aircraft using hardware shown in Figure 3.
10. Locate D2237 striker plates based on door latch location. Transfer drill 0.128" (3.3mm) diameter holes and install per Figure 4 using MS20470AD4-5 rivets.
11. Install gas spring assembly per Figure 5.
12. Check Door for proper operation by opening and closing the door.

3.2 D350-588-011 Fwd Hinge Aft Door Kit, Installation Procedure

Use Figures 6 to 7 when installing the D350-588-011 Kit.

1. Remove existing door from the aircraft.
2. Cut away inside skin and core in the location of D2583 brackets, if required.
3. Use D2583 as a template and trace through inner rectangle. Cut hole through door skin in rectangle area for door latch. Deburr edges of hole and install D2583 using 5 minute epoxy or potting resin from section 7.2 of QSI 037.
4. Draw construction line as shown in Figure 6 to locate D2143/D2144 brackets.
5. Cut away inside skin and core in the location of D2143/D2144 brackets and install cloth doubler in each bracket location as shown in Section B-B of Figure 7. Use 9 oz. S-Class (or equivalent) glass cloth and bond with laminating resin per section 7.2 of QSI 037. D2143/D2144 brackets can be installed on top of cloth doubler after resin has cured.
6. Transfer drill 0.171" (4.4mm) diameter holes from D2143/D2144 brackets to door.
7. Remove existing latch. Clean area on inside and bond D2587 plug (provided) over hole and fill hole with 5 minute epoxy or a potting resin from section 7.2 of QSI 037. Sand on outside when dry.
8. Fill old hinge holes with MS20470AD3-4 rivets (provided).
9. For installation on the 355N aircraft, the copper bonding straps should be re-located as follows:
 - i. Remove existing copper bonding straps and plug rivet holes with AD rivets.
 - ii. Touch up conductive paint on outside of door.
 - iii. Install (re-install) copper bonding straps adjacent to new hinge locations.
 - iv. Relocate bonding jumpers to new hinge locations.
 - v. Ensure hinge hardware does not damage conductive door seal.
 - vi. Prime all exposed aluminum.
10. Install Modified Door per section 3.1

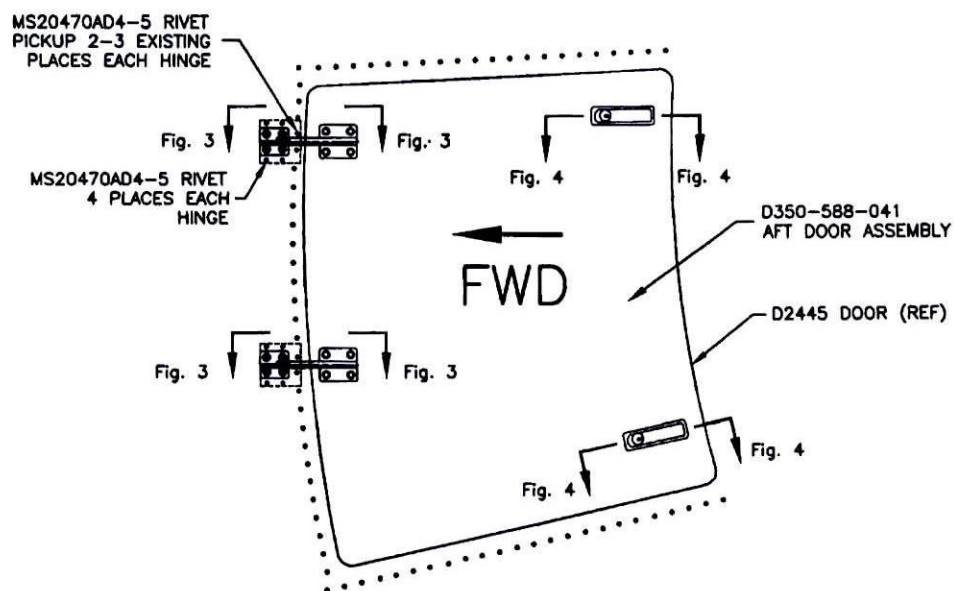


Figure 2: Baggage Door Outside View

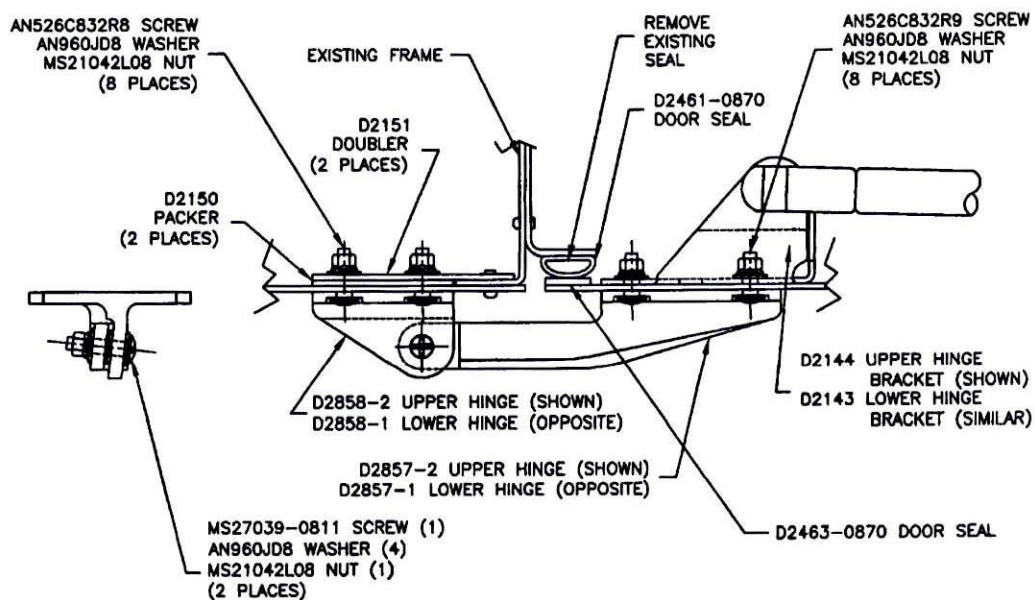


Figure 3: Hinge Detail

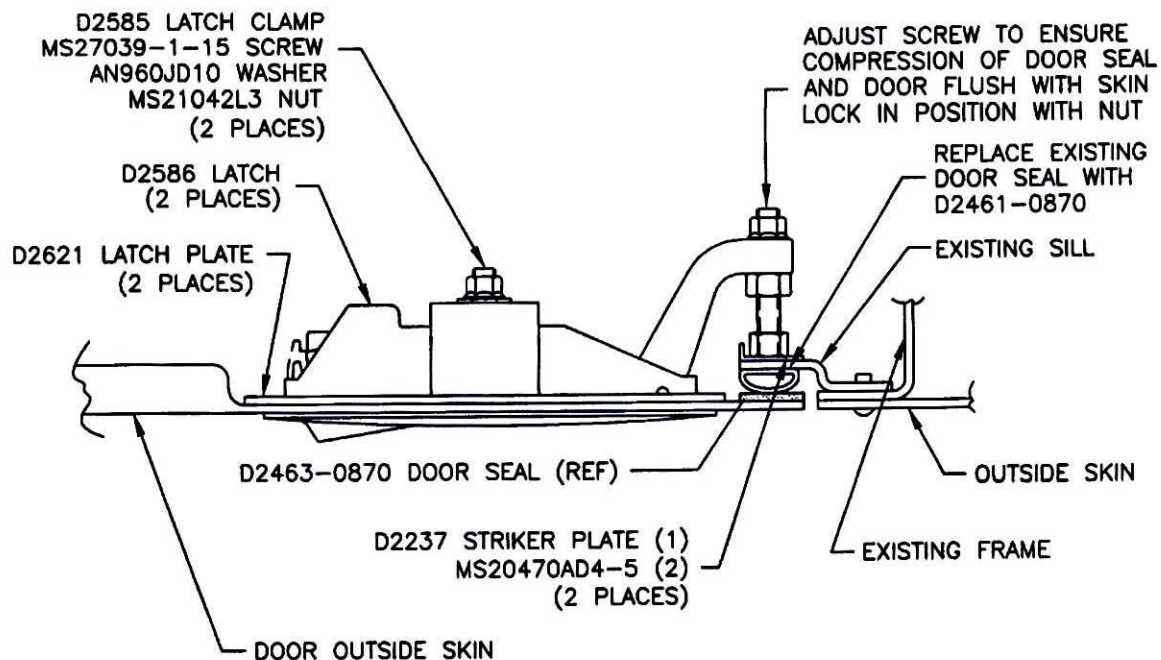


Figure 4: Latch Section

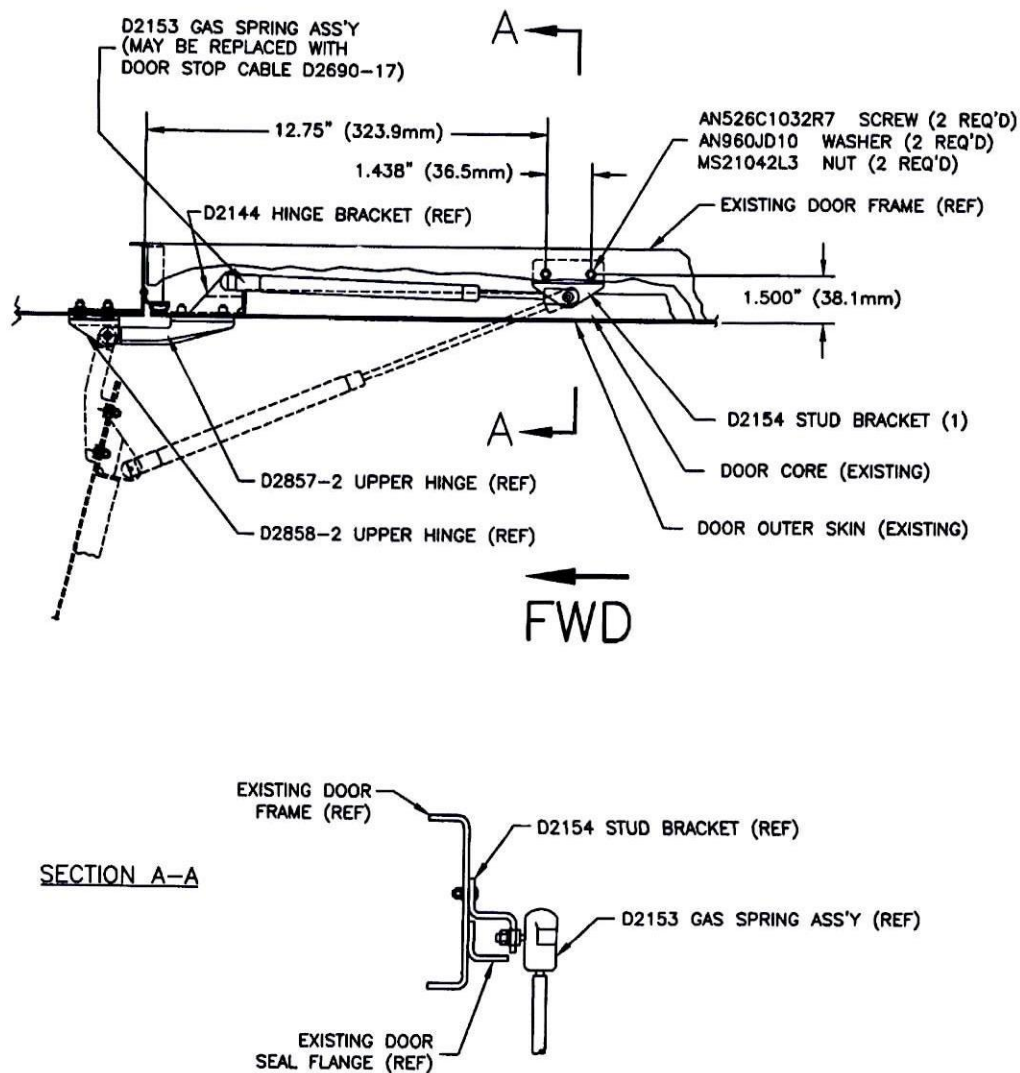


Figure 5: Gas Spring Installation

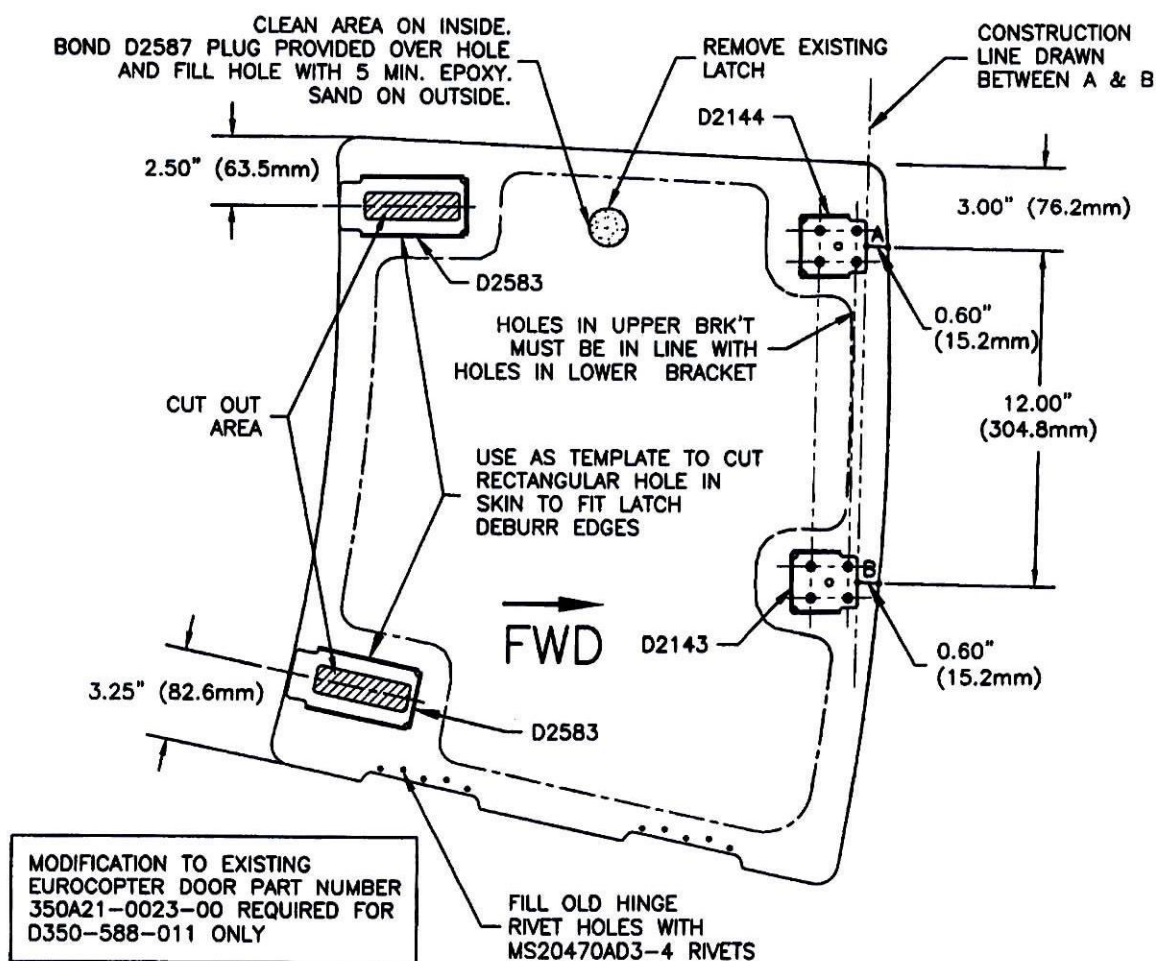


Figure 6: Baggage Door Inside View

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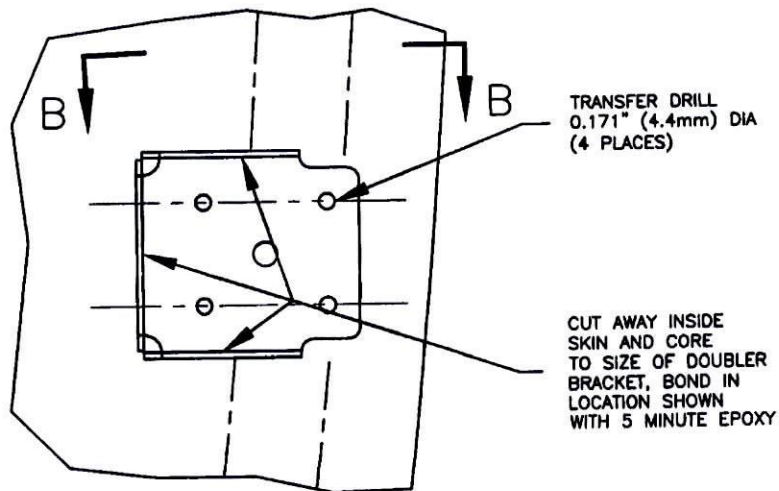
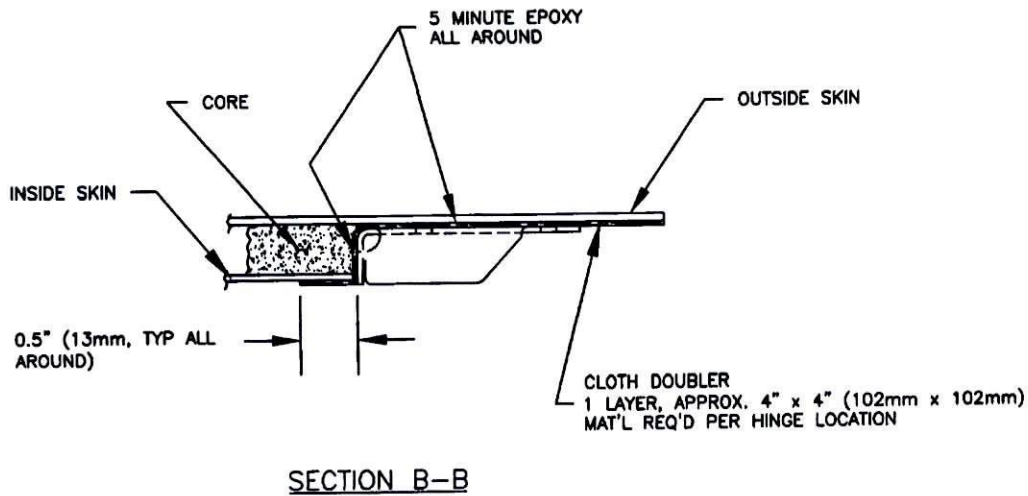


Figure 7: Typical Doubler Bracket Installation

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

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	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
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1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17

REFERENCE ONLY

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
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X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

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MFG. APPR.	N/A	DSI 9690 SHEET 2 OF 2
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Page 1

Tuesday, September 26, 2017 12:53:08 PM

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Revision ID:

Stop ***NS2***

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Start Date: 9/26/2017 Start Qty: 1.00

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Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D
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